

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003578**Date Inspected:** 04-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** see below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Tower Shop-Bay 1

QA Observations: General On-Going Fabrication- Caltrans QA Inspector randomly observed ZPMC continuing with the fabrication of various Tower Skin Assembly for the 1st lift, Segments 1, 2 & 3. The general fabrication of items consists of removing of coating from weld joint areas, cutting, beveling, splicing of plates, fitting, tack welding and welding.

In process Bevel & Prep - Caltrans QA Inspector randomly observed ZPMC in the process of torch cut beveling of stiffener plates, heat straightening skin & stiffener plates, splice welding stiffener plates using an SAW process for the South Tower Skin Assembly, Skin A.

Fit-Up & Tack - Caltrans QA Inspector randomly observed ZPMC in the process of fit-up, tack welding and heat straightening for the South Tower Skin Assembly, Skin E using a SMAW process on this date.

In-Process Welding - Caltrans QA Inspector randomly observed ZPMC in the process of performing PJP weld using a 2 gantry system for the South Tower Skin Assembly, Skin A using a FCAW process on this date.

Tower Shop-Bay 2

QA Observations: General On-Going Fabrication- Caltrans QA Inspector randomly observed ZPMC continuing with the fabrication of various Tower Skin Assembly for the 1st lift, Segments 1, 2 & 3. The general fabrication of items consists of removing of coating from weld joint areas, cutting, beveling, splicing of plates, fitting, tack

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welding and welding.

In process Bevel & Prep - Caltrans QA Inspector randomly observed ZPMC in the process of torch cut beveling of stiffener plates, heat straightening skin & stiffener plates, splice welding stiffener plates using an SAW process for the East Tower Skin Assembly, Skin B.

Fit-Up & Tack - Caltrans QA Inspector randomly observed ZPMC in the process of fit-up, tack welding and heat straightening for the East Tower Skin Assembly, Skin E using a SMAW process on this date.

In-Process Welding - Caltrans QA Inspector randomly observed ZPMC in the process of performing PJP weld using a 2 gantry system for the East Tower Skin Assembly, Skin A using a FCAW process on this date.

Tower Shop-Bay 3 (deck panels)

QA Observations: General On-Going repairs- Caltrans QA Inspector randomly observed ZPMC continuing with the repairs of Deck Panels designated for the SAS OBG closed ribs. The repair's consists of grinding and welding on Deck Panels PJP welds that have been previously visually verified ZPMC, ABF and CT. ZPMC personnel UT close ribs deck panel DP325-002 on this date.

Summary of Conversations:

No relevant conversations to report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
